

## ABSTRACT:

A roll forming machine that can form material with a complex profile, such as a miter or coping, in the ends of the work piece is described. A length sensor provides information to a computer that monitors the amount of material being formed and a machining section is installed before the forming rollers. This allows the invention to cut the desired end profile before the material is roll formed into the final shape. Since the material is flat during the cutting operation, any of the standard cutting techniques known in the art, can be employed, such as shearing, punching or a CNC end mill.